



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

**D206-642-151**  
**Job Sheet 192882**



**Part No:** D206-642-151

**Job Qty:** 1 pcs

**Part Name:** Replacement Skidtube, Low Gear with Run-on Landing Fits LH or RH



**Part Weight:** 0 lbs

**Status:** New

**Priority:** Medium

**Job Created:** 4/3/19

**Job Tracking No:**

**Due Date:** 4/19/19

**Created By:** Marie Lajeunesse

**Type:** SOLD

**Description:**

**Note:** DWG D3804 REV A(DEO), IIN-D206-642 REV Q SHEETS 13,26 IPP REV:A 10.12.08 PER IIN REV.N DD  
VERF:EC IPP REV:B 11.09.16 PER IIN REV.O DD VERF:EC IPP Rev:C 12.11.22 now swage per ecn12-679  
DD verf:JLM IPP Rev:D 14.04.24 ECN14-520 DD verf:JLM IPP Rev:E 16.04.04 as per CHG004(ecn16-553)  
DD verf:JLM

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation     | Qty   | Start Date | Due Date | Standard Setup Hrs | Run Hrs | Workcenter/Supplier | Lead Time | Sign-off    |
|-------|---------------|-------|------------|----------|--------------------|---------|---------------------|-----------|-------------|
| 110   | Skidtubes - 1 | 1 pcs | 4/19/19    |          | 0.00               | 1.82    | Skidtubes - 1       |           | JD          |
|       |               |       |            |          |                    |         | Skidtubes - 2       |           |             |
|       |               |       |            |          |                    |         | Skidtubes - 3       |           |             |
|       |               |       |            |          |                    |         | Skidtubes - 4       |           |             |
|       |               |       |            |          |                    |         | Skidtubes - 5       |           | BE          |
|       |               |       |            |          |                    |         | Skidtubes - 6       |           |             |
|       |               |       |            |          |                    |         | Skidtubes - 7       |           |             |
| 120   | QC 5          | 1 pcs | 4/19/19    |          | 0.00               | 0.00    | QC 5 - 10           |           |             |
|       |               |       |            |          |                    |         | QC 5 - 12           |           |             |
|       |               |       |            |          |                    |         | QC 5 - 17           |           |             |
|       |               |       |            |          |                    |         | QC 5 - 18           |           |             |
|       |               |       |            |          |                    |         | QC 5 - 19           |           |             |
|       |               |       |            |          |                    |         | QC 5 - 22           |           |             |
|       |               |       |            |          |                    |         | QC 5 - 24           |           |             |
|       |               |       |            |          |                    |         | QC 5 - 3            |           |             |
|       |               |       |            |          |                    |         | QC 5 - 43           |           |             |
|       |               |       |            |          |                    |         | QC 5 - 49           |           |             |
|       |               |       |            |          |                    |         | QC 5 - 51           |           |             |
|       |               |       |            |          |                    |         | QC 5 - 58           |           |             |
|       |               |       |            |          |                    |         | QC 5 - 68           |           |             |
|       |               |       |            |          |                    |         | QC 5 - 9            |           | JD 19-04-15 |
|       |               |       |            |          |                    |         | QC 5 - 50           |           |             |
|       |               |       |            |          |                    |         | QC 5 - 30           |           |             |
|       |               |       |            |          |                    |         | QC 5 - 40           |           |             |
| 130   | QC 9          | 1 pcs | 4/19/19    |          | 0.00               | 0.00    | QC 9 - 10           |           |             |
|       |               |       |            |          |                    |         | QC 9 - 18           |           |             |
|       |               |       |            |          |                    |         | QC 9 - 24           |           |             |
|       |               |       |            |          |                    |         | QC 9 - 43           |           |             |
|       |               |       |            |          |                    |         | QC 9 - 50           |           |             |



Dart Aerospace Ltd.  
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**Container No:** S172126



**Part:** D206-642-151

**Job No:** 192882

**Serial No/Batch:** S172126

**Revision:**

**Inspector:**

**Exp Date:**

**Instructions:** FAA STC SA00475SE 18/10/17, TC STC SH98-4 Issue 2, EASA STC

Plex 4/3/19 11:01 AM Dart.lajeunesse.marie



|                                   |       |         |           |                           |                         |
|-----------------------------------|-------|---------|-----------|---------------------------|-------------------------|
| 140 Handfinish - 1-1 Chemical-B4B | 1 pcs | 4/19/19 | 0.00 0.33 | QC 9 - 9                  | PD 19-04-15             |
|                                   |       |         |           | Handfinish - 1 - 1 - B4B  |                         |
|                                   |       |         |           | Handfinish - 1 - 2 - B4B  |                         |
|                                   |       |         |           | Handfinish - 1 - 3 - B4B  |                         |
|                                   |       |         |           | Handfinish - 1 - 4 - B4B  |                         |
|                                   |       |         |           | Handfinish - 1 - 5 - B4B  |                         |
|                                   |       |         |           | Handfinish - 1 - 6 - B4B  |                         |
|                                   |       |         |           | Handfinish - 1 - 7 - B4B  |                         |
|                                   |       |         |           | Handfinish - 1 - 8 - B4B  |                         |
|                                   |       |         |           | Handfinish - 1 - 9 - B4B  |                         |
|                                   |       |         |           | Handfinish - 1 - 10 - B4B | D.R 19/07/15            |
|                                   |       |         |           | Handfinish - 1 - 11 - B4B |                         |
|                                   |       |         |           | Handfinish - 1 - 12 - B4B |                         |
|                                   |       |         |           | Handfinish - 1 - 13 - B4B |                         |
|                                   |       |         |           | Handfinish - 1 - 14 - B4B |                         |
|                                   |       |         |           | Handfinish - 1 - 15 - B4B |                         |
|                                   |       |         |           | Handfinish - 1 - 16 - B4B |                         |
|                                   |       |         |           | Handfinish - 1 - 17 - B4B |                         |
|                                   |       |         |           | Handfinish - 1 - 18 - B4B |                         |
|                                   |       |         |           | Handfinish - 1 - 19 - B4B |                         |
|                                   |       |         |           | Handfinish - 1 - 20 - B4B |                         |
|                                   |       |         |           | Handfinish - 1 - 21 - B4B |                         |
|                                   |       |         |           | Handfinish - 1 - 22 - B4B |                         |
| 150 QC 7                          | 1 pcs | 4/19/19 | 0.00 0.00 | QC 7 - 10                 |                         |
|                                   |       |         |           | QC 7 - 13                 |                         |
|                                   |       |         |           | QC 7 - 14                 |                         |
|                                   |       |         |           | QC 7 - 15                 |                         |
|                                   |       |         |           | QC 7 - 17                 |                         |
|                                   |       |         |           | QC 7 - 18                 |                         |
|                                   |       |         |           | QC 7 - 19                 |                         |
|                                   |       |         |           | QC 7 - 2                  |                         |
|                                   |       |         |           | QC 7 - 28                 |                         |
|                                   |       |         |           | QC 7 - 3                  |                         |
|                                   |       |         |           | QC 7 - 30                 |                         |
|                                   |       |         |           | QC 7 - 34                 |                         |
|                                   |       |         |           | QC 7 - 36                 |                         |
|                                   |       |         |           | QC 7 - 37                 |                         |
|                                   |       |         |           | QC 7 - 41                 |                         |
|                                   |       |         |           | QC 7 - 47                 |                         |
|                                   |       |         |           | QC 7 - 48                 |                         |
|                                   |       |         |           | QC 7 - 51                 |                         |
|                                   |       |         |           | QC 7 - 58                 |                         |
|                                   |       |         |           | QC 7 - 59                 |                         |
|                                   |       |         |           | QC 7 - 60                 | MGB                     |
|                                   |       |         |           | QC 7 - 9                  |                         |
|                                   |       |         |           | QC 7 - 68                 |                         |
| QC 7 - 50                         |       |         |           |                           |                         |
| QC 7 - 67                         |       |         |           |                           |                         |
|                                   |       |         |           | Plex 4/3/19 11:01         | AM Dart.lajeunesse.mari |

|                                            |          |         |           |                     |             |
|--------------------------------------------|----------|---------|-----------|---------------------|-------------|
|                                            |          |         |           | QC 7 - 40           |             |
| 160 Skidtubes - 2 - B4B                    | 1<br>pcs | 4/19/19 | 0.00 2.00 | Skidtubes - 1 - B4B |             |
|                                            |          |         |           | Skidtubes - 2 - B4B |             |
|                                            |          |         |           | Skidtubes - 3 - B4B |             |
|                                            |          |         |           | Skidtubes - 4 - B4B | TF          |
|                                            |          |         |           | Skidtubes - 5 - B4B |             |
|                                            |          |         |           | Skidtubes - 6 - B4B |             |
|                                            |          |         |           | Skidtubes - 7 - B4B |             |
| 180 Skidtubes - 3 - B4B                    | 1<br>pcs | 4/19/19 | 0.00 1.82 | Skidtubes - 1 - B4B |             |
|                                            |          |         |           | Skidtubes - 2 - B4B |             |
|                                            |          |         |           | Skidtubes - 3 - B4B |             |
|                                            |          |         |           | Skidtubes - 4 - B4B | TF          |
|                                            |          |         |           | Skidtubes - 5 - B4B |             |
|                                            |          |         |           | Skidtubes - 6 - B4B |             |
|                                            |          |         |           | Skidtubes - 7 - B4B |             |
| 190 QC 5                                   | 1<br>pcs | 4/19/19 | 0.00 0.00 | QC 5 - 10           |             |
|                                            |          |         |           | QC 5 - 12           |             |
|                                            |          |         |           | QC 5 - 17           |             |
|                                            |          |         |           | QC 5 - 18           | DE          |
|                                            |          |         |           | QC 5 - 19           |             |
|                                            |          |         |           | QC 5 - 22           |             |
|                                            |          |         |           | QC 5 - 24           |             |
|                                            |          |         |           | QC 5 - 3            |             |
|                                            |          |         |           | QC 5 - 43           |             |
|                                            |          |         |           | QC 5 - 49           |             |
|                                            |          |         |           | QC 5 - 51           |             |
|                                            |          |         |           | QC 5 - 58           |             |
|                                            |          |         |           | QC 5 - 68           |             |
|                                            |          |         |           | QC 5 - 9            |             |
|                                            |          |         |           | QC 5 - 50           |             |
|                                            |          |         |           | QC 5 - 30           |             |
|                                            |          |         |           | QC 5 - 40           |             |
| 200 Skidtubes - 4 - B4B                    | 1<br>pcs | 4/19/19 | 0.00 2.84 | Skidtubes - 1 - B4B |             |
|                                            |          |         |           | Skidtubes - 2 - B4B |             |
|                                            |          |         |           | Skidtubes - 3 - B4B |             |
|                                            |          |         |           | Skidtubes - 4 - B4B | TF          |
|                                            |          |         |           | Skidtubes - 5 - B4B | DE          |
|                                            |          |         |           | Skidtubes - 6 - B4B |             |
|                                            |          |         |           | Skidtubes - 7 - B4B |             |
| 215 QC 9                                   | 1<br>pcs | 4/19/19 | 0.00 0.00 | QC 9 - 10           |             |
|                                            |          |         |           | QC 9 - 18           | DAS         |
|                                            |          |         |           | QC 9 - 24           | 24          |
|                                            |          |         |           | QC 9 - 43           | 9-89        |
|                                            |          |         |           | QC 9 - 50           |             |
|                                            |          |         |           | QC 9 - 9            |             |
|                                            |          |         |           |                     | APR 24 2019 |
| 230 QC 5                                   | 1<br>pcs | 4/19/19 | 0.00 0.00 | QC 5 - 10           |             |
|                                            |          |         |           | QC 5 - 12           |             |
|                                            |          |         |           | QC 5 - 17           |             |
|                                            |          |         |           | QC 5 - 18           |             |
|                                            |          |         |           | QC 5 - 19           |             |
|                                            |          |         |           | QC 5 - 22           |             |
|                                            |          |         |           | QC 5 - 24           |             |
|                                            |          |         |           | QC 5 - 3            |             |
|                                            |          |         |           | QC 5 - 43           |             |
|                                            |          |         |           | QC 5 - 49           |             |
|                                            |          |         |           | QC 5 - 51           |             |
|                                            |          |         |           | QC 5 - 58           |             |
|                                            |          |         |           | QC 5 - 68           |             |
|                                            |          |         |           | QC 5 - 9            |             |
|                                            |          |         |           | DAS                 |             |
|                                            |          |         |           | MAY 01 2019         |             |
|                                            |          |         |           | 68                  |             |
|                                            |          |         |           | 9-89                |             |
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|     |                                |          |         |           |                           |              |
|-----|--------------------------------|----------|---------|-----------|---------------------------|--------------|
|     |                                |          |         |           | QC 5 - 50                 |              |
|     |                                |          |         |           | QC 5 - 30                 |              |
|     |                                |          |         |           | QC 5 - 40                 |              |
| 240 | Handfinish - 4-1-Assembly-B4B  | 1<br>pcs | 4/19/19 | 0.00 0.78 | Handfinish - 4 - 1 - B4B  | DR 19/05/02  |
|     |                                |          |         |           | Handfinish - 4 - 10 - B4B |              |
|     |                                |          |         |           | Handfinish - 4 - 11 - B4B |              |
|     |                                |          |         |           | Handfinish - 4 - 12 - B4B |              |
|     |                                |          |         |           | Handfinish - 4 - 13 - B4B |              |
|     |                                |          |         |           | Handfinish - 4 - 14 - B4B |              |
|     |                                |          |         |           | Handfinish - 4 - 15 - B4B |              |
|     |                                |          |         |           | Handfinish - 4 - 2 - B4B  |              |
|     |                                |          |         |           | Handfinish - 4 - 3 - B4B  |              |
|     |                                |          |         |           | Handfinish - 4 - 4 - B4B  |              |
|     |                                |          |         |           | Handfinish - 4 - 5 - B4B  |              |
|     |                                |          |         |           | Handfinish - 4 - 6 - B4B  |              |
|     |                                |          |         |           | Handfinish - 4 - 7 - B4B  |              |
|     |                                |          |         |           | Handfinish - 4 - 8 - B4B  |              |
|     |                                |          |         |           | Handfinish - 4 - 9 - B4B  |              |
| 250 | Powdercoat - 1 White Gl(A)-B4B | 1<br>pcs | 4/19/19 | 0.00 0.25 | Powdercoat - 1 - B4B      |              |
|     |                                |          |         |           | Powdercoat - 2 - B4B      |              |
|     |                                |          |         |           | Powdercoat - 3 - B4B      | DR 19-5-16   |
|     |                                |          |         |           | Powdercoat - 4 - B4B      |              |
| 260 | QC 3                           | 1<br>pcs | 4/19/19 | 0.00 0.00 | QC 3 - 10                 |              |
|     |                                |          |         |           | QC 3 - 13                 |              |
|     |                                |          |         |           | QC 3 - 15                 |              |
|     |                                |          |         |           | QC 3 - 17                 |              |
|     |                                |          |         |           | QC 3 - 18                 |              |
|     |                                |          |         |           | QC 3 - 2                  |              |
|     |                                |          |         |           | QC 3 - 28                 |              |
|     |                                |          |         |           | QC 3 - 3                  |              |
|     |                                |          |         |           | QC 3 - 30                 |              |
|     |                                |          |         |           | QC 3 - 34                 |              |
|     |                                |          |         |           | QC 3 - 36                 |              |
|     |                                |          |         |           | QC 3 - 41                 |              |
|     |                                |          |         |           | QC 3 - 51                 |              |
|     |                                |          |         |           | QC 3 - 58                 |              |
|     |                                |          |         |           | QC 3 - 59                 | BEB 19-05-21 |
|     |                                |          |         |           | QC 3 - 68                 |              |
|     |                                |          |         |           | QC 3 - 9                  |              |
|     |                                |          |         |           | QC 3 - 40                 |              |
|     |                                |          |         |           | QC 3 - 19                 |              |
| 270 | Handfinish - 4-2-Assembly-B4B  | 1<br>pcs | 4/19/19 | 0.00 1.00 | Handfinish - 4 - 1 - B4B  |              |
|     |                                |          |         |           | Handfinish - 4 - 10 - B4B | BEB 19-05-21 |
|     |                                |          |         |           | Handfinish - 4 - 11 - B4B |              |
|     |                                |          |         |           | Handfinish - 4 - 12 - B4B |              |
|     |                                |          |         |           | Handfinish - 4 - 13 - B4B |              |
|     |                                |          |         |           | Handfinish - 4 - 14 - B4B |              |
|     |                                |          |         |           | Handfinish - 4 - 15 - B4B |              |
|     |                                |          |         |           | Handfinish - 4 - 2 - B4B  |              |

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|                                    |       |         |           |                          |                                            |  |
|------------------------------------|-------|---------|-----------|--------------------------|--------------------------------------------|--|
|                                    |       |         |           |                          | Handfinish - 4 - 3 - B4B                   |  |
|                                    |       |         |           |                          | Handfinish - 4 - 4 - B4B                   |  |
|                                    |       |         |           |                          | Handfinish - 4 - 5 - B4B                   |  |
|                                    |       |         |           |                          | Handfinish - 4 - 6 - B4B                   |  |
|                                    |       |         |           |                          | Handfinish - 4 - 7 - B4B                   |  |
|                                    |       |         |           |                          | Handfinish - 4 - 8 - B4B                   |  |
|                                    |       |         |           |                          | Handfinish - 4 - 9 - B4B                   |  |
| 280 Handfinish - 3-1- WingWalk-B4B | 1 pcs | 4/19/19 | 0.00 0.60 | Handfinish - 3 - 1 - B4B |                                            |  |
|                                    |       |         |           | Handfinish - 3 - 2 - B4B | BEB19-05-23.                               |  |
|                                    |       |         |           | Handfinish - 3 - 3 - B4B |                                            |  |
|                                    |       |         |           | Handfinish - 3 - 4 - B4B |                                            |  |
|                                    |       |         |           | Handfinish - 3 - 5 - B4B |                                            |  |
| 290 QC 3                           | 1 pcs | 4/19/19 | 0.00 0.00 | QC 3 - 10                |                                            |  |
|                                    |       |         |           | QC 3 - 13                |                                            |  |
|                                    |       |         |           | QC 3 - 15                |                                            |  |
|                                    |       |         |           | QC 3 - 17                |                                            |  |
|                                    |       |         |           | QC 3 - 18                |                                            |  |
|                                    |       |         |           | QC 3 - 2                 |                                            |  |
|                                    |       |         |           | QC 3 - 28                | DAS                                        |  |
|                                    |       |         |           | QC 3 - 3                 | 19                                         |  |
|                                    |       |         |           | QC 3 - 30                | 9-00                                       |  |
|                                    |       |         |           | QC 3 - 34                |                                            |  |
|                                    |       |         |           | QC 3 - 36                |                                            |  |
|                                    |       |         |           | QC 3 - 41                |                                            |  |
|                                    |       |         |           | QC 3 - 51                |                                            |  |
|                                    |       |         |           | QC 3 - 58                |                                            |  |
|                                    |       |         |           | QC 3 - 59                |                                            |  |
|                                    |       |         |           | QC 3 - 68                |                                            |  |
|                                    |       |         |           | QC 3 - 9                 |                                            |  |
|                                    |       |         |           | QC 3 - 40                |                                            |  |
|                                    |       |         |           | QC 3 - 19                |                                            |  |
| 300 QC 5                           | 1 pcs | 4/19/19 | 0.00 0.00 | QC 5 - 10                |                                            |  |
|                                    |       |         |           | QC 5 - 12                |                                            |  |
|                                    |       |         |           | QC 5 - 17                |                                            |  |
|                                    |       |         |           | QC 5 - 18                |                                            |  |
|                                    |       |         |           | QC 5 - 19                |                                            |  |
|                                    |       |         |           | QC 5 - 22                |                                            |  |
|                                    |       |         |           | QC 5 - 24                | DAS                                        |  |
|                                    |       |         |           | QC 5 - 3                 | 19                                         |  |
|                                    |       |         |           | QC 5 - 43                | 9-00                                       |  |
|                                    |       |         |           | QC 5 - 49                |                                            |  |
|                                    |       |         |           | QC 5 - 51                |                                            |  |
|                                    |       |         |           | QC 5 - 58                |                                            |  |
|                                    |       |         |           | QC 5 - 68                |                                            |  |
|                                    |       |         |           | QC 5 - 9                 |                                            |  |
|                                    |       |         |           | QC 5 - 50                |                                            |  |
|                                    |       |         |           | QC 5 - 30                |                                            |  |
|                                    |       |         |           | QC 5 - 40                |                                            |  |
| 310 Packaging 3-1 - Stock - B4B    | 1 pcs | 4/19/19 | 0.00 0.00 | Packaging 3 - 1 - B4B    |                                            |  |
|                                    |       |         |           | Packaging 3 - 2 - B4B    |                                            |  |
|                                    |       |         |           | Packaging 3 - 3 - B4B    |                                            |  |
|                                    |       |         |           | Packaging 3 - 4 - B4B    |                                            |  |
|                                    |       |         |           | Packaging 3 - 5 - B4B    | DAS                                        |  |
|                                    |       |         |           | Packaging 3 - 6 - B4B    | 28                                         |  |
|                                    |       |         |           | Packaging 3 - 7 - B4B    | 9-89                                       |  |
|                                    |       |         |           | Packaging 3 - 8 - B4B    |                                            |  |
|                                    |       |         |           | Packaging 3 - 9 - B4B    |                                            |  |
|                                    |       |         |           | Packaging 3 - 10 - B4B   |                                            |  |
|                                    |       |         |           | Packaging 3 - 11 - B4B   |                                            |  |
|                                    |       |         |           |                          | Plex 4/3/19 11:01 AM Dart.lajeunesse.marie |  |



|                  |     |         |           |                        |                    |
|------------------|-----|---------|-----------|------------------------|--------------------|
|                  |     |         |           | Packaging 3 - 12 - B4B |                    |
|                  |     |         |           | Packaging 3 - 13 - B4B |                    |
|                  |     |         |           | Packaging 3 - 14 - B4B |                    |
|                  |     |         |           | Packaging 3 - 15 - B4B |                    |
|                  |     |         |           | Packaging 3 - 16 - B4B |                    |
|                  |     |         |           | Packaging 3 - 17 - B4B |                    |
|                  |     |         |           | Packaging 3 - 18 - B4B |                    |
|                  |     |         |           | Packaging 3 - 19 - B4B |                    |
|                  |     |         |           | Packaging 3 - 20 - B4B |                    |
|                  |     |         |           | Packaging 3 - 21 - B4B |                    |
|                  |     |         |           | Packaging 3 - 22 - B4B |                    |
|                  |     |         |           | Packaging 3 - 23 - B4B |                    |
|                  |     |         |           | Packaging 3 - 24 - B4B |                    |
|                  |     |         |           | Packaging 3 - 25 - B4B |                    |
|                  |     |         |           | Packaging 3 - 26 - B4B |                    |
|                  |     |         |           | Packaging 3 - 27 - B4B |                    |
|                  |     |         |           | Packaging 3 - 28 - B4B |                    |
|                  |     |         |           | Packaging 3 - 29 - B4B |                    |
|                  |     |         |           | Packaging 3 - 30 - B4B |                    |
|                  |     |         |           | Packaging 3 - 31 - B4B |                    |
|                  |     |         |           | Packaging 3 - 32 - B4B |                    |
|                  |     |         |           | Packaging 3 - 33 - B4B |                    |
|                  |     |         |           | Packaging 3 - 34 - B4B |                    |
|                  |     |         |           | Packaging 3 - 35 - B4B |                    |
|                  |     |         |           | Packaging 3 - 36 - B4B |                    |
| 315 DC - 1 - B4B | 1   | 4/19/19 | 0.00 0.00 | DC - 1 - B4B           | DAG JUN 18 2019    |
|                  | pcs |         |           | DC - 2 - B4B           | 21                 |
| 320 QC 21 - FG   | 1   | 4/19/19 | 0.00 0.00 | QC 21 - FG - 21        | 9-89               |
|                  | pcs |         |           | QC 21 - FG - 70        | DAG 21 JUN 18 2019 |

Part Op 110 - Skidtubes - 1-Deburr Fwd edge of tube 2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804 3-Weld  
 Descriptions: Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required. *AK 138969*

120 - QC5- Inspect part completeness to step on W/O

130 - QC9- Inspect visual per QSI004- Fusion Welds

140 - Chemical Conversion Coat per QSI005 4.1

150 - QC7-Inspect Chemical Conversion Coat

160 - Skidtubes --1-Open holes of detail B to finished size as per Dwg DEO D3804, (without cutting fluid) 2-C'sink one crossbolt spacer hole as per Dwg D3804 DEO Detail B(without cutting fluid) 3-Deburr and blow out all chips from inside the tube

180 - Skidtubes - 1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required 2-Bond D2654-1 web in place as per QSI 015. Ensure holes line up.Allow 12 Hrs. cure time before cutting

190 - QC5- Inspect part completeness to step on W/O

200 - 1-Remove alodine in one area see DEO Detail B from around hole and prepare for welding 2-Prep per QSI 005 and Insert one D2649 crossbolt spacer. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

215 - QC9- Inspect visual per QSI004- Fusion Welds

230 - QC5- Inspect part completeness to step on W/O

240 - Pressure Wash per QSI005 4.3/ Clean and remove all markings) HandFinish4 Assemble as per dwg

250 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs. START TIME: \_\_\_\_\_

260 - QC3- Inspect Part Finish

270 - HandFinish4 (Assemble as per dwg - - 1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D3804. Clean excess adhesive. 2- Install D2680-041 Nut Plate as per Dwg D2650

280 - Wing Walk as per dwg QSI005 4.4 Batch *5163430* 1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive

290 - QC3- Inspect Part Finish

300 - QC5- Inspect part completeness to step on W/O

310 - Identify and pack for shipping as per PPP D206-642-151 Location :FG107

315 - Document Control - Photocopy bluefile & type labels per PPP D206-642-151 CHG004

320 - QC21- Final Inspection - Work Order Release

*Sika flex  
5163437  
exp 12/09/19*

*Sika flex 5174342 Exp: 12/12.*



## Job BOM

| Part / Item   | Component Name               | Quantity       | Operation                          | Container          |
|---------------|------------------------------|----------------|------------------------------------|--------------------|
| D2620         | Skidtube, 206 Skidtube       | 1 pcs (1 ea)   | 110-Skidtubes - 1                  | 5165744            |
| D2647         | Cap                          | 1 pcs (1 ea)   | 110-Skidtubes - 1                  | 5166088            |
| CCR264SS3-3   | Cherry Rivet                 | 2 Ea (2 ea)    | 180-Skidtubes - 3 - B4B            | FM137622           |
| CR3212-4-03   | Cherry Rivet                 | 2 Ea (2 ea)    | 180-Skidtubes - 3 - B4B            | FM137886-0         |
| CR3212-4-04   | Cherry Rivet                 | 52 Ea (52 ea)  | 180-Skidtubes - 3 - B4B            | 5171694            |
| D2654-1       | Web                          | 1 pcs (1 ea)   | 180-Skidtubes - 3 - B4B            | 5060133            |
| D3286-1       | Doubler                      | 2 pcs (2 ea)   | 180-Skidtubes - 3 - B4B            | 5164714            |
| D2649         | Cross Bolt Spacer            | 1 pcs (1 ea)   | 200-Skidtubes - 4 - B4B            | 5156887            |
| D3286-3       | Spacer                       | 2 pcs (2 ea)   | 200-Skidtubes - 4 - B4B            | 5140137            |
| D4720-1       | Spacer                       | 18 pcs (18 ea) | 200-Skidtubes - 4 - B4B            | 5154519            |
| D2651-1       | Plug                         | 6 pcs (6 ea)   | 270-Handfinish - 4-2-Assembly-B4B  | 5167951            |
| D2651-3       | O-Ring                       | 6 pcs (6 ea)   | 270-Handfinish - 4-2-Assembly-B4B  | 5014502            |
| D2680-041     | Nut Plate                    | 1 pcs (1 ea)   | 270-Handfinish - 4-2-Assembly-B4B  | 5164243            |
| AN3-37A       | Bolt                         | 7 Ea (7 ea)    | 280-Handfinish - 3-1- WingWalk-B4B | 515135486/25166888 |
| D2646         | Aft Cap                      | 1 pcs (1 ea)   | 280-Handfinish - 3-1- WingWalk-B4B | 5160607            |
| D3805-041     | Run-on Landing Wearplate Fwd | 1 pcs (1 ea)   | 280-Handfinish - 3-1- WingWalk-B4B | 5145465            |
| D3805-045     | Run-on Landing Wearplate Aft | 1 pcs (1 ea)   | 280-Handfinish - 3-1- WingWalk-B4B | 5182526            |
| D3873-1       | Bushing                      | 14 pcs (14 ea) | 280-Handfinish - 3-1- WingWalk-B4B | 5172675            |
| MS21042L3     | Nut                          | 7 Ea (7 ea)    | 280-Handfinish - 3-1- WingWalk-B4B | 5157462-1          |
| MS27039-1-08  | Screw                        | 2 Ea (2 ea)    | 280-Handfinish - 3-1- WingWalk-B4B | 5180295            |
| MS27039-4-06  | Screw                        | 1 Ea (1 ea)    | 280-Handfinish - 3-1- WingWalk-B4B | 5166974-1          |
| NAS1149D0332J | Washer                       | 2 Ea (2 ea)    | 280-Handfinish - 3-1- WingWalk-B4B | 5178328            |
| NAS1149D0363J | Washer                       | 7 Ea (7 ea)    | 280-Handfinish - 3-1- WingWalk-B4B | 5162884            |
| NAS1149D0463J | Washer                       | 1 Ea (1 ea)    | 280-Handfinish - 3-1- WingWalk-B4B | 5055952            |

## Job Allocations

| Operation                          | Component Part | Required | Inventory | Allocated |
|------------------------------------|----------------|----------|-----------|-----------|
| 110-Skidtubes - 1                  | D2620          | 1        | 9         | 0         |
|                                    | D2647          | 1        | 48        | 0         |
| 180-Skidtubes - 3 - B4B            | CCR264SS3-3    | 2        | 243       | 0         |
|                                    | CR3212-4-03    | 2        | 120       | 0         |
|                                    | CR3212-4-04    | 52       | 641       | 0         |
|                                    | D2654-1        | 1        | 7         | 0         |
|                                    | D3286-1        | 2        | 10        | 0         |
| 200-Skidtubes - 4 - B4B            | D2649          | 1        | 76        | 0         |
|                                    | D3286-3        | 2        | 16        | 0         |
|                                    | D4720-1        | 18       | 242       | 0         |
| 270-Handfinish - 4-2-Assembly-B4B  | D2651-1        | 6        | 243       | 0         |
|                                    | D2651-3        | 6        | 382       | 0         |
|                                    | D2680-041      | 1        | 23        | 0         |
| 280-Handfinish - 3-1- WingWalk-B4B | AN3-37A        | 7        | 91        | 0         |
|                                    | D2646          | 1        | 58        | 0         |
|                                    | D3805-041      | 1        | 5         | 0         |
|                                    | D3805-045      | 1        | 6         | 0         |
|                                    | D3873-1        | 14       | 26        | 0         |
|                                    | MS21042L3      | 7        | 3,790     | 0         |
|                                    | MS27039-1-08   | 2        | 751       | 0         |
|                                    | MS27039-4-06   | 1        | 113       | 0         |
|                                    | NAS1149D0332J  | 2        | 3,634     | 0         |
|                                    | NAS1149D0363J  | 7        | 1,614     | 0         |
|                                    | NAS1149D0463J  | 1        | 5,667     | 0         |

## Part Specifications

Specifications could not be found.



| ITEM | Qty<br>-041 | Qty<br>-043 | Part Number  | Description                     |
|------|-------------|-------------|--------------|---------------------------------|
| 1    | X           |             | D3804-041    | SKIDTUBE ASSEMBLY, 206 A/B LOW  |
| 2    |             | X           | D3804-043    | SKIDTUBE ASSEMBLY, 206 A/B HIGH |
| 5    | 1           | 1           | D2600-1-160  | EXTRUSION                       |
| 6    | 1           | 1           | D2646        | AFT CAP                         |
| 7    | 1           | 1           | D2647        | CAP                             |
| 8    | 19          | 20          | D2649        | CROSS BOLT SPACER               |
| 9    | 6           | 8           | D2651-1      | PLUG                            |
| 10   | 6           | 8           | D2651-3      | O-RING                          |
| 11   |             | 1           | D2654-3      | WEB                             |
| 12   | 1           |             | D2654-1      | WEB                             |
| 13   | 1           | 1           | D2680-041    | NUT PLATE                       |
| 14   | 2           | 2           | D3286-1      | DOUBLER                         |
| 15   | 2           | 2           | D3286-3      | STUD                            |
| 21   | 2           | 2           | AN960JD10L   | WASHER                          |
| 22   | 1           | 1           | AN960JD416   | WASHER                          |
| 23   | 2           | 2           | CCR264SS3-3  | RIVET                           |
| 24   | 2           | 2           | CR3212-4-03  | RIVET                           |
| 25   | 52          | 52          | CR3212-4-04  | RIVET                           |
| 26   | 2           | 2           | MS27039-1-08 | SCREW                           |
| 27   | 1           | 1           | MS27039-4-06 | SCREW                           |

#### NOTES

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 lb
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 192882 M15  
190405

DEO ATTACHED

RELEASED  
UP 09.03.07  
per ECN 09-538

|            |             |    |          |
|------------|-------------|----|----------|
| A          | NEW ISSUE   | MB | 08.07.07 |
| REV.       | DESCRIPTION | BY | DATE     |
| DESIGN     | 97          |    |          |
| DRAWN      | h           |    |          |
| CHECKED    | 9           |    |          |
| MFG. APPR. | EE          |    |          |
| APPROVED   | 97          |    |          |
| DE APPR.   | 97          |    |          |
| DATE       | 08.07.07    |    |          |

|                                                                                                                                                                                                                                                                                                    |              |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DART AEROSPACE USA, INC                                                                                                                                                                                                                                                                            |              |
| PORT HADLOCK, WA                                                                                                                                                                                                                                                                                   |              |
| DRAWING NO.<br>D3804                                                                                                                                                                                                                                                                               | REV. A       |
| TITLE<br>SKIDTUBE ASSEMBLY, 206A/B                                                                                                                                                                                                                                                                 | SCALE<br>NTS |
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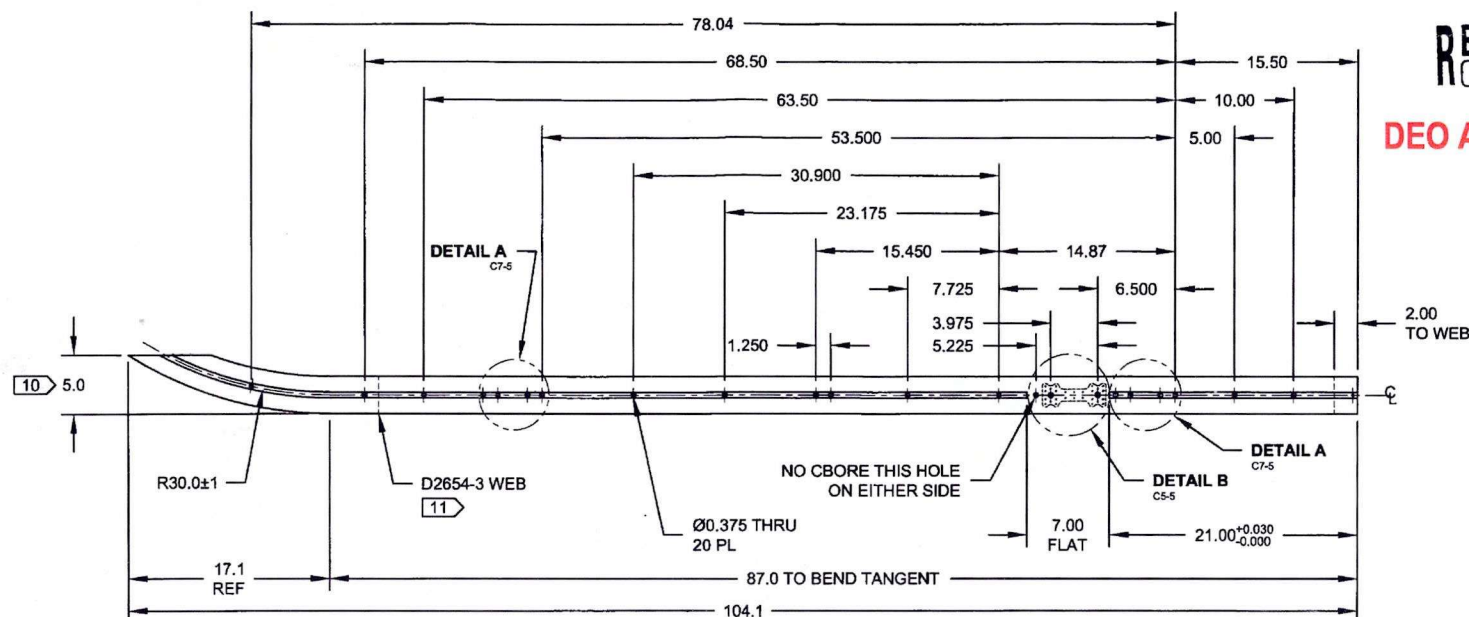




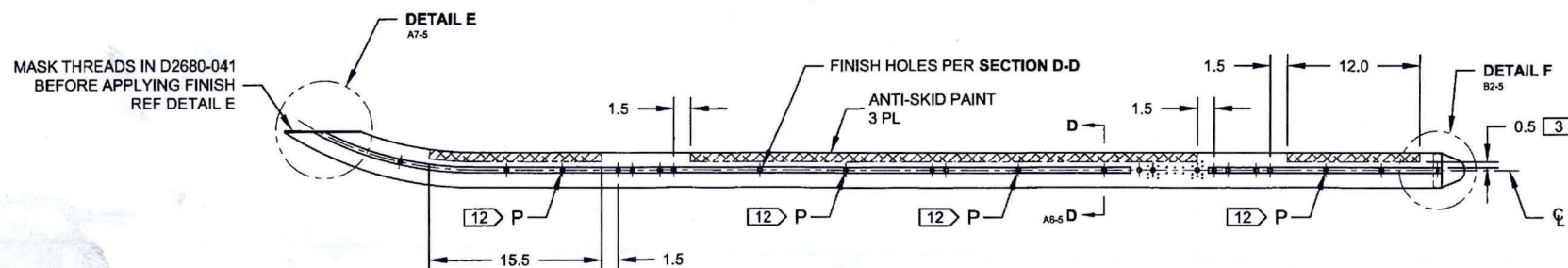


**RELEASED**  
(U 09-09-03)

**DEO ATTACHED**



**D3804-043 BENDING/DRILLING DETAIL**

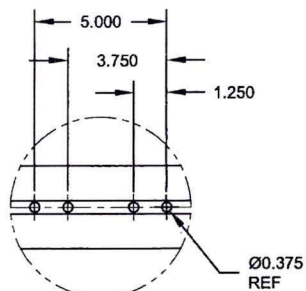


**D3804-043 ASSEMBLY/FINISHING DETAIL**

|                                                                                                                                                                                                                                     |          |                                             |              |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------|---------------------------------------------|--------------|
| DESIGN                                                                                                                                                                                                                              | 49       | <b>DART AEROSPACE USA, INC</b>              |              |
| DRAWN                                                                                                                                                                                                                               | 49       | PORT HADLOCK, WA                            |              |
| CHECKED                                                                                                                                                                                                                             | 49       | DRAWING NO.                                 | REV. A       |
| MFG. APPR.                                                                                                                                                                                                                          | 49       | D3804                                       | SHEET 3 OF 5 |
| APPROVED                                                                                                                                                                                                                            | 49       | TITLE                                       | SCALE        |
| DE APPR.                                                                                                                                                                                                                            | 49       | SKIDTUBE ASSEMBLY, 206A/B                   | NTS          |
| DATE                                                                                                                                                                                                                                | 08.07.07 | COPYRIGHT © 2006 BY DART AEROSPACE USA, INC |              |
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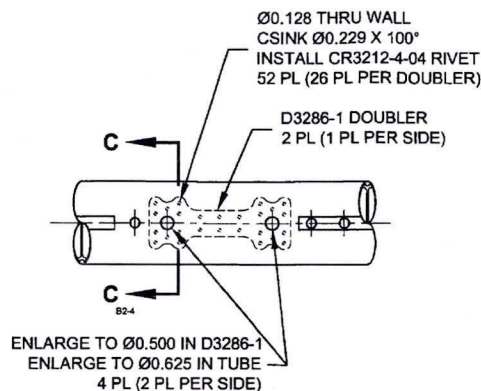


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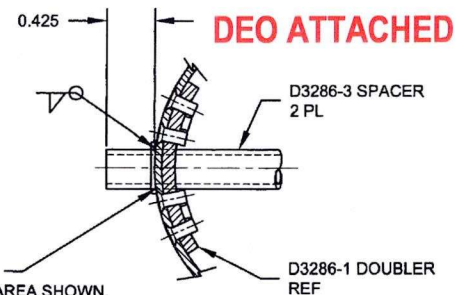
**DETAIL A**  
SCALE NONE

D6-2  
C2-2  
D6-3  
C2-3



**DETAIL B**  
SCALE NONE

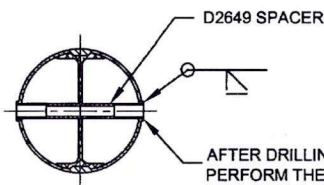
C3-2  
C3-3



- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
  2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
  3. ENLARGE HOLES IN D3286-1 TO Ø0.500
  4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
  5. RIVET D3286-1 TO TUBE
  6. INSERT D3286-3 SPACER
  7. WELD IN PLACE AND GRIND FLUSH

**SECTION C-C**  
PARTIAL SECTION  
SCALE NONE

C6-4



- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.03 X 45°
  2. INSERT D2649 SPACER
  3. WELD INTO PLACE AND GRIND FLUSH
  4. CBORE TO Ø0.313 X 0.75 DP (EXCEPT WHERE INDICATED)

**SECTION D-D**  
FOR Ø0.375 HOLES ONLY  
SCALE NONE

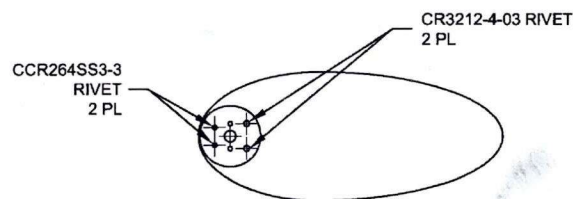
A4-2  
A4-3

|                                                                                                                                                                                                                                     |          |                                             |              |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------|---------------------------------------------|--------------|
| DESIGN                                                                                                                                                                                                                              | 9        | <b>DART AEROSPACE USA, INC</b>              |              |
| DRAWN                                                                                                                                                                                                                               | J        | PORT HADLOCK, WA                            |              |
| CHECKED                                                                                                                                                                                                                             | 9        | DRAWING NO.                                 | REV. A       |
| MFG. APPR.                                                                                                                                                                                                                          | E        | D3804                                       | SHEET 4 OF 5 |
| APPROVED                                                                                                                                                                                                                            | 9        | TITLE                                       | SCALE        |
| DE APPR.                                                                                                                                                                                                                            | H        | SKIDTUBE ASSEMBLY, 206A/B                   | NTS          |
| DATE                                                                                                                                                                                                                                | 08.07.07 | COPYRIGHT © 2008 BY DART AEROSPACE USA, INC |              |
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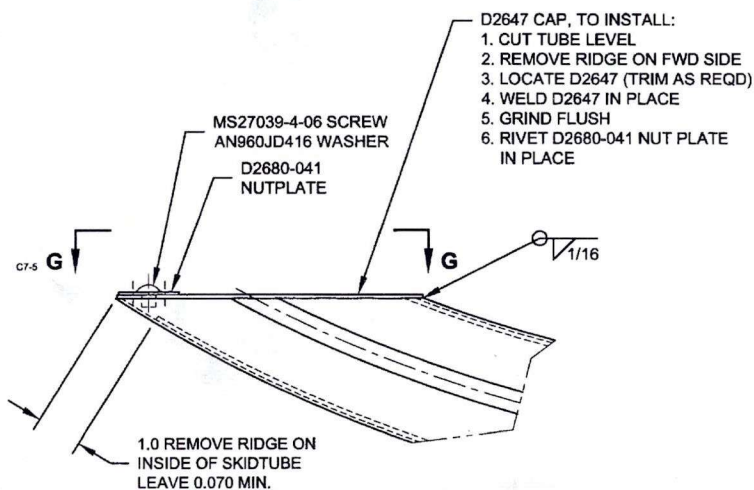
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09.03.03

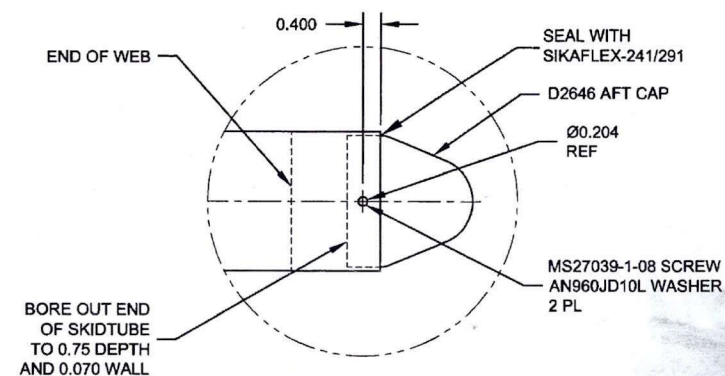
DEO ATTACHED



**VIEW G-G**  
SCALE NONE  
A7-5



**DETAIL E**  
SCALE NONE  
B7-2  
B7-3



**DETAIL F**  
SCALE NONE  
B2-2  
B2-3

|            |          |                                                                                                                                                                                                                                                                                                    |              |
|------------|----------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     | 99       | <b>DART AEROSPACE USA, INC</b>                                                                                                                                                                                                                                                                     |              |
| DRAWN      | 99       | PORT HADLOCK, WA                                                                                                                                                                                                                                                                                   |              |
| CHECKED    | 99       | DRAWING NO.                                                                                                                                                                                                                                                                                        | REV. A       |
| MFG. APPR. | 99       | D3804                                                                                                                                                                                                                                                                                              | SHEET 5 OF 5 |
| APPROVED   | 99       | TITLE                                                                                                                                                                                                                                                                                              | SCALE        |
| DE APPR.   | 99       | SKIDTUBE ASSEMBLY, 206A/B                                                                                                                                                                                                                                                                          | NTS          |
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|                      |                                      |                                  |                                         |                                |                         |                           |              |
|----------------------|--------------------------------------|----------------------------------|-----------------------------------------|--------------------------------|-------------------------|---------------------------|--------------|
| DRAWING NO.<br>D3804 | TITLE<br>SKIDTUBE ASSEMBLIES, 206A/B | REV. A                           | DART AEROSPACE LTD<br>ENGINEERING ORDER |                                | D.E.O. NO.<br>D3804-A-1 | SHEET NO.<br>SHEET 1 OF 1 | SCALE<br>NTS |
| DRAWN<br><i>CP</i>   | CHECKED<br><i>A.P.</i>               | MFG. APPR.<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i>          | DE APPR.<br><i>[Signature]</i> |                         |                           |              |
| DATE<br>12.10.12     | DATE<br>12.10.22                     | DATE<br>12.10.22                 | DATE<br>12.10.22                        | DATE<br>12.10.22               |                         |                           |              |

**PURPOSE:**

CHANGE C'BORED WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

**CHANGE:**

PARTS LIST IS AMENDED AS FOLLOWS:

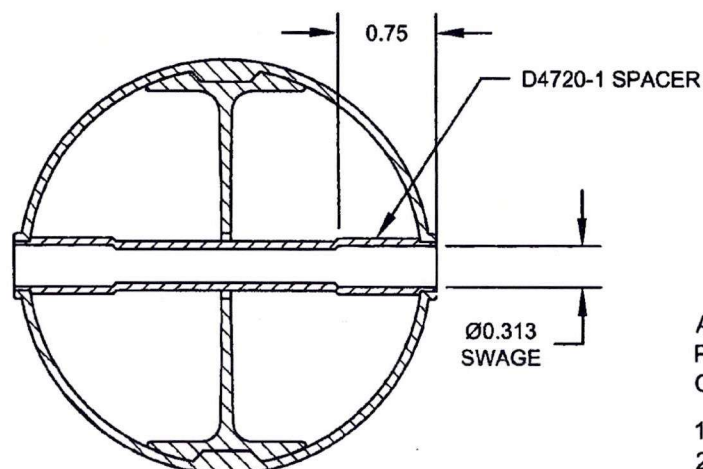
IS:

| QTY<br>-041 | QTY<br>-043 | PART NUMBER | DESCRIPTION       |
|-------------|-------------|-------------|-------------------|
| 1           | 1           | D2649       | CROSS BOLT SPACER |
| 18          | 19          | D4720-1     | SPACER            |

WAS:

|    |    |       |                   |
|----|----|-------|-------------------|
| 19 | 20 | D2649 | CROSS BOLT SPACER |
|----|----|-------|-------------------|

ADD SECTION H-H BELOW, WHICH IS THE SAME SECTION VIEW AS SECTION D-D OF DWG.  
C'BORED HOLES ARE NOW SWAGED PER SECTION H-H BELOW. FOR THE Ø0.375 HOLE THAT IS NOT C'BORED, WELD PER SECTION D-D OF DWG (SEE AMENDED DETAIL B FOR REFERENCE).

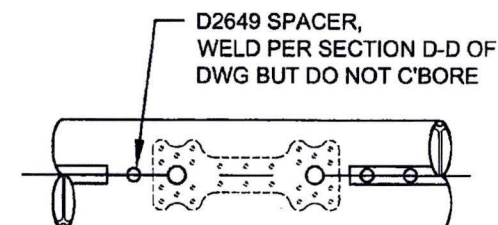


**SECTION H-H**

FOR Ø0.375 HOLES ONLY

FOR HOLES THAT ARE CURRENTLY C'BORED ONLY

NOT TO SCALE



**DETAIL B**

AMENDMENT TO DETAIL B  
NOT TO SCALE

RELEASE  
2012-11-16

AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø0.375 HOLES THAT ARE  
CURRENTLY C'BORED:

1. INSERT D4720-1 SPACER, 18 PL (-041) OR 19 PL (-043)
2. SWAGE TO Ø0.313 X 0.75 DP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |  |                        |  |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|------------------------|--|
| Job: _____<br><br>Part No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> | <b>DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Water Jet <input type="checkbox"/><br/>           Supplier <input type="checkbox"/><br/>           Quality <input type="checkbox"/> </div> </div>                                                                                                                                                                                                                                                                      |  |                        |  |
| Date :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | Sequence #:                                                                                                                       | QTY Affected :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |  | MRB (QSI042)           |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                   | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |  | Completed By           |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |  | Lead hand / Supervisor |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |  |                        |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |  | QC / QA Coordinator    |  |
| <b>Root Cause</b><br><br><div style="display: flex;"> <div style="flex: 1;">           Operator <input type="checkbox"/><br/>           Manufacturing Process <input type="checkbox"/><br/>           Equip/Tooling <input type="checkbox"/><br/>           Handling/Preservation <input type="checkbox"/><br/>           Material <input type="checkbox"/><br/>           Product Improvement <input type="checkbox"/><br/>           Process Improvement <input type="checkbox"/><br/>           Human Factors <input type="checkbox"/> </div> <div style="flex: 1;"> <input type="checkbox"/> Pressure/Forced<br/> <input type="checkbox"/> Bending<br/> <input type="checkbox"/> Crushing<br/> <input type="checkbox"/> Cracks<br/> <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist<br/> <input type="checkbox"/> Marks/Chatter<br/> <input type="checkbox"/> Mislabeled         </div> </div> |                                                                                                                                   | <b>FAULT CATEGORY</b><br><br><div style="display: flex;"> <div style="flex: 1;"> <input type="checkbox"/> Contamination<br/> <input type="checkbox"/> Misaligned/off center<br/> <input type="checkbox"/> BOM/Route<br/> <input type="checkbox"/> Broken/Damage/Defect<br/> <input type="checkbox"/> Incomplete/Unclear Instructions<br/> <input type="checkbox"/> Drill Holes<br/> <input type="checkbox"/> Fit/Function         </div> <div style="flex: 1;"> <input type="checkbox"/> Power Loss/Surge<br/> <input type="checkbox"/> Folio/Program<br/> <input type="checkbox"/> Grain Direction<br/> <input type="checkbox"/> Weld<br/> <input type="checkbox"/> Wrong Stock Pulled<br/> <input type="checkbox"/> Out of Sequence<br/> <input type="checkbox"/> Off-set/Set-up         </div> <div style="flex: 1;"> <input type="checkbox"/> Positioned Wrong<br/> <input type="checkbox"/> Outside Tolerance<br/> <input type="checkbox"/> Drawing<br/> <input type="checkbox"/> Finish<br/> <input type="checkbox"/> Part Lost/Missing<br/> <input type="checkbox"/> Misread         </div> </div> |  |                        |  |
| Other/Details:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |  |                        |  |



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